

Work Order ID 63858

November 17, 2010 8:26:47 AM

PRELIMINARY ISSUE

Page 1

Item ID: D3608-1

Accept



Setup Start



Revision ID:

Item Name: Lower Doubler

Stop



Start Date: 11/17/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3608	PC1

100



FLOW WATER JET

Waterjet

Memo

0.00

10-11-17

FLOW CNC Waterjet

1-Cut as per Dwg D3608
Dwg Rev: *PC1*
Prog Rev: *PC1*
2-Deburr if necessary

(1)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

10-11-17

Quality Control

120



QC8- Inspect parts - second check

0.00 - ins Pcto b PC1

QC

Memo

0.00

Day only
S10/17 *X1*

Work Order ID 63858

November 17, 2010 8:26:48 AM



Page 2

Item ID: D3608-1

Accept



Setup

Start



Revision ID:

Item Name: Lower Doubler

Stop



Start Date: 11/17/10 Start Qty: 1.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

150



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location:

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

u 10/11/17

Ship to Eng
Harvey

0.00

ENG 11/06

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

POSITIVE RECALL
EFFECTIVE 10/11/17 AUTH u RELEASED u DATE 10/11/22

Karen M. P. 10/11/23

u 10/11/17 ~

Picklist Print

November 17, 2010 8:26:46 AM

Page 1

Work Order ID: 63858



Parent Item: D3608-1



Parent Item Name: Lower Doubler

Start Date: 11/17/10

Required Date: 11/17/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-03-26 JLM
IPP Rev:B 08-10-15 preliminary issue DD verified by:EC
IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP
Rev:D 10.02.16 rev.B as per dwg DD verified by:EC IPP Rev:E
10.11.17 as per PC1 dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	109.3000	0.7392	0.778105		B0-11-17	

Location	Loc Qty	Loc Code
MAT	105.3	
115762	10.2	
115953	95.1	<u>115953</u>
MAT20	4	
113062	1.398	
115440	2.602	

(1)

DART AEROSPACE LTD	Work Order:	63858
Description: LOWER Doubler	Part Number:	D3608-1
Inspection Dwg:D3608-1 , Rev: PC1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

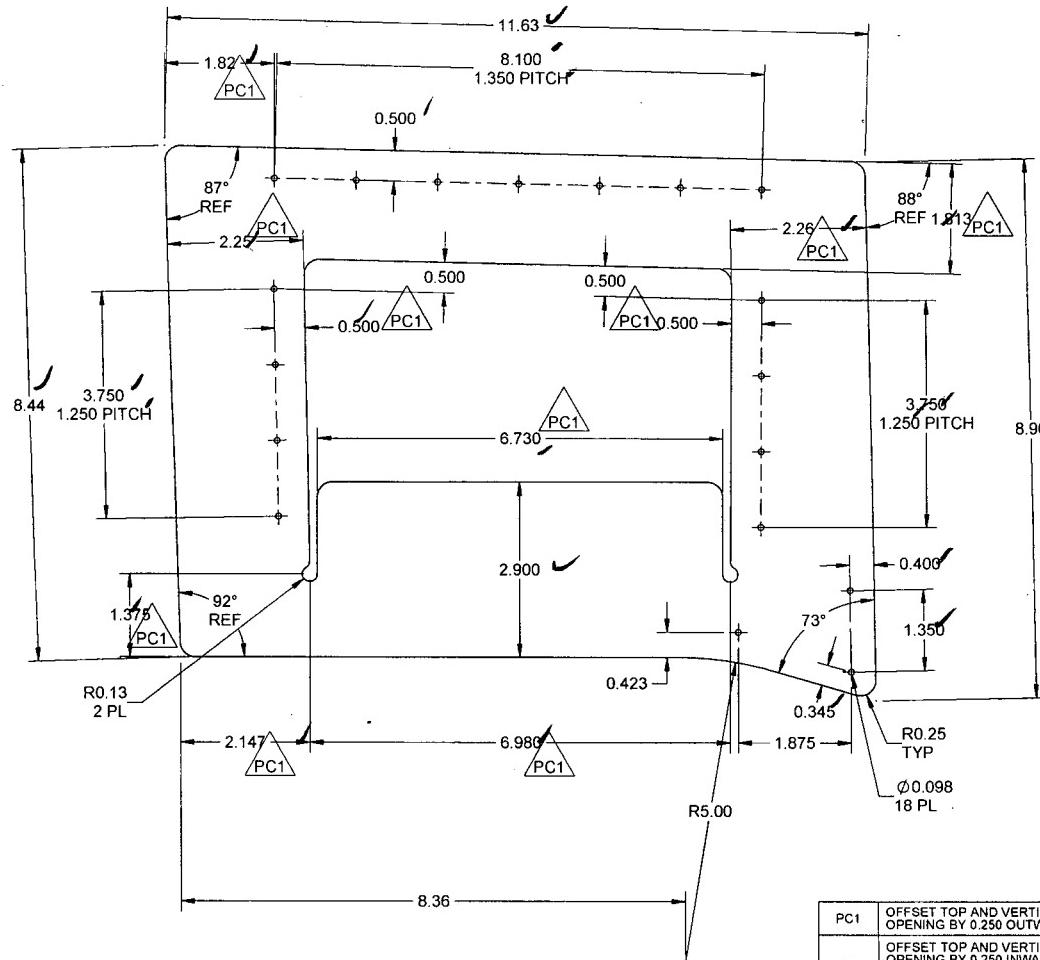
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
∅ .098	+ .064 - .001	.101	*		✓ HB02	
1.82	+/- .030	1.814	*		✓	
8.100	+/- .010	8.094	*		✓ PRO HB02	
1.350	+/- .010	1.343	*		✓	
11.63	+/- .030	11.622	*		✓ PRO HB02	
2.26	+/- .030	2.268	*		✓	
1.813	+/- .010	1.816	*		✓	
.500	+/- .010	.507	*		✓	
3.750	+/- .010	3.743	*		✓	
1.250	+/- .010	1.242	*		✓	
.400	+/- .010	.400	*		✓	
1.350	+/- .010	1.342	*		✓	
8.90	+/- .030	8.892	*		✓ PRO HB02	
.345	+/- .010	.343	*		✓	
1.875	+/- .010	1.875	*		✓	
.423	+/- .010	.419	*		✓	
6.980	+/- .010	6.980	*		✓	
2.147	+/- .010	2.153	*		✓	
1.375	+/- .010	1.375	*		✓	
8.44	+/- .030	8.432	*		✓ PRO HB02	
6.730	+/- .010	6.735	*		✓	
.038	+/- .010	.036	*		✓	

Measured by:	B
Date:	10-11-17

Audited by:	S
Date:	10/11/17

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue to PC1 Day only	KJ/JLM	



D3608-1 LOWER DOUBLER

NOTES:

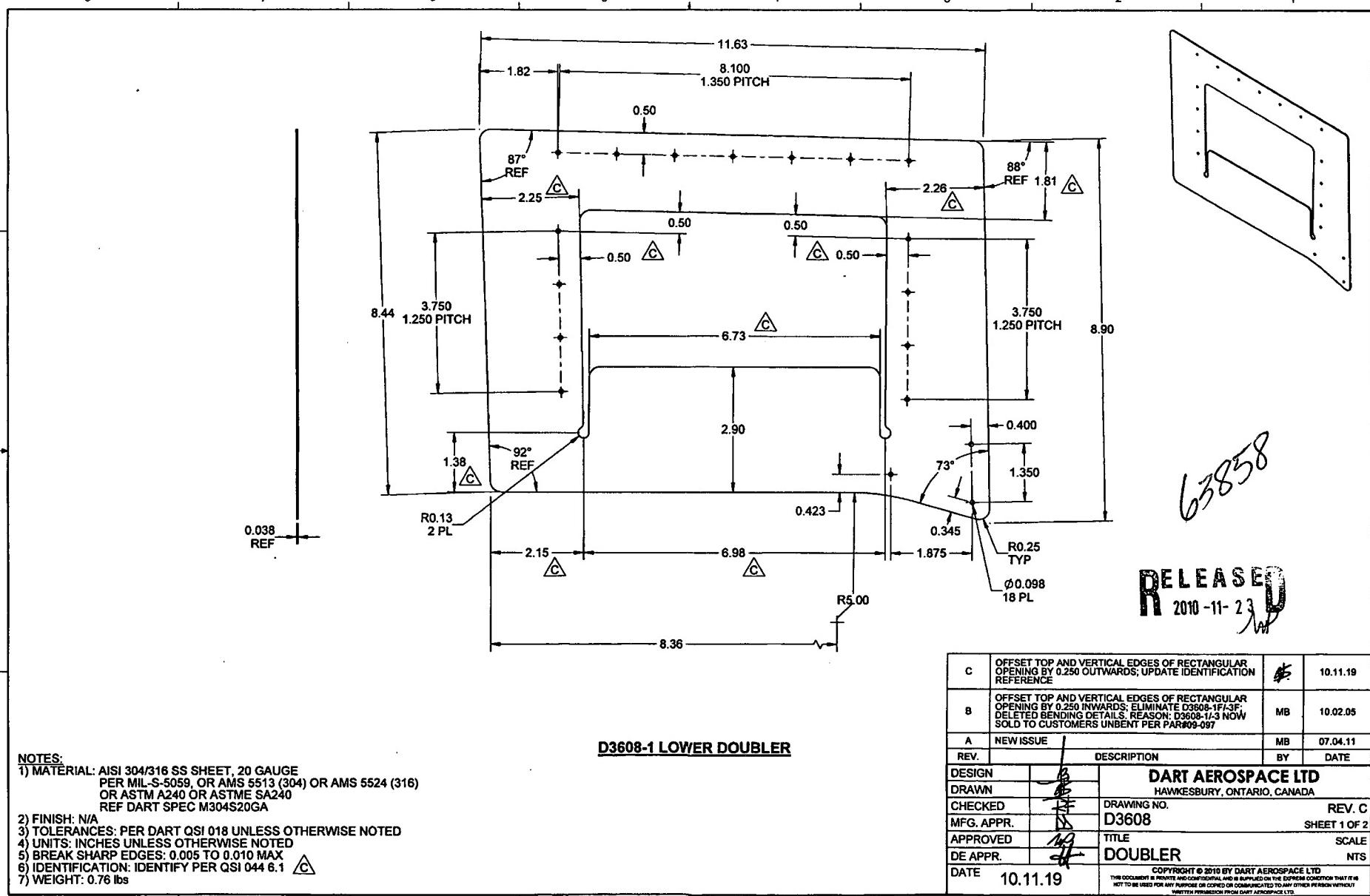
- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASTME SA240
REF DART SPEC M304SS20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.76 lbs

PRELIMINARY ISSUE

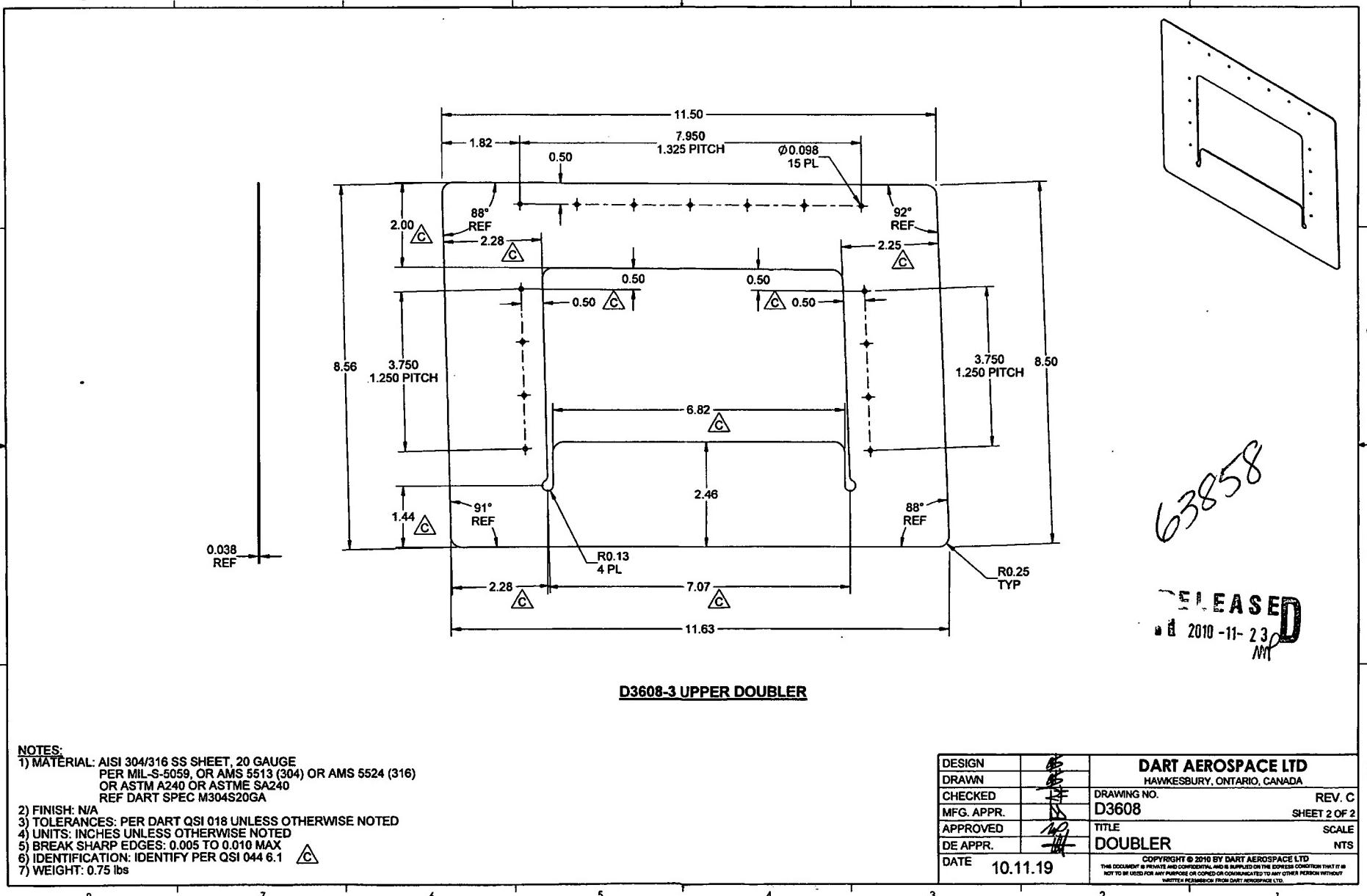
10.11.15

PC1	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 OUTWARDS	AS	10.11.15
B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARDS; ELIMINATE D3608-1F-3F; DELETED BENDING DETAILS. REASON: D3608-1/3 NOW SOLD TO CUSTOMERS UNBENT PER PAR#09-097	MB	10.02.05
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION		
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	DRAWING NO. REV. PC1		
CHECKED	D3608		
MFG. APPR.	SHEET 1 OF 2		
APPROVED	TITLE		
DE APPR.	SCALE DOUBLER		
DATE	NTS 10.11.15		

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C	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 OUTWARDS; UPDATE IDENTIFICATION REFERENCE	<input checked="" type="checkbox"/>	10.11.19
B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARDS; ELIMINATE D3608-1F/3F; DELETED BENDING DETAILS, REASON: D3608-1/3 NOW SOLD TO CUSTOMERS UNBENT PER PAR#09-097	<input type="checkbox"/>	MB 10.02.05
A	NEW ISSUE	<input type="checkbox"/>	MB 07.04.11
REV.		BY	DATE
DESIGN	<input checked="" type="checkbox"/>	DART AEROSPACE LTD	
DRAWN	<input checked="" type="checkbox"/>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<input checked="" type="checkbox"/>	DRAWING NO.	REV. C
MFG. APPR.	<input checked="" type="checkbox"/>	D3608	SHEET 1 OF 2
APPROVED	<input checked="" type="checkbox"/>	TITLE	SCALE
DE APPR.	<input checked="" type="checkbox"/>	DOUBLER	NTS
DATE	10.11.19	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 
 - 7) WEIGHT: 0.75 lbs

DESIGN	<u>AS</u>	DART AEROSPACE LTD
DRAWN	<u>BS</u>	HAWKSBURY, ONTARIO, CANADA
CHECKED	<u>HF</u>	DRAWING NO.
MFG. APPR.	<u>DS</u>	R.E.V. C
APPROVED	<u>MO</u>	D3608 SHEET 2 OF 2
DE APPR.	<u>MM</u>	TITLE SCALE
DATE	10.11.19	DOUBLER NTS

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